95284

Page 1

Insp.

Thursday, January 24, 2013 12:27:24 PM D3183-043 Item ID: Accept *N900040100* Setup Start **Revision ID:** Bracket Assembly Item Name: Stop **Start Date:** 1/7/2013 Start Qty: 3.00 **Cust Item ID:** Required Date: 1/8/2013 Req'd Qty: 3.00 **Customer:** CU-DAR001 RMA RAII1456 - Return Reference: M Date: (3-1-24 Run **Approvals:** Process Plan: Tooling: Date: Stop QC: Date: SPC(Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Work Center ID Description **Run Hours** Qty Code Qty Number Stamp Draw Nbr Revision Nbr D3183 Rev C1 100 0.00 *100* QC Memo Quality Control INSPECT RA 111456 D3183-043 X 3 B82688

PART ARE GOOD

*OLD BATCH NUMBER NEEDS TO BE BUFFED AND NEW BATCH

NUMBER SCRIBBED ON*

110

110

Small Fab

Small Fab

Memo

0.00

0.00

BUFF OUT OLD BATCH NUMBER

SCRIBE NEW BATCH NUMBER IN SAME LOCATION

												DQA:	Date:		
NCR:	⁄es	/ No					WORK ORDER NON-O	10:	NFORM	MANCE / UPI	DATE	04.01	D-4-		
	-							_				QA Closed:	Date:		
Work Order:							DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
WORK OTA	-1.						Rework]		Skid-tube	Crosstube	1	Water Jet	Engineering	
Part N	۱o.						Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
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NCR 1	١o.						Work Order Update]		Large Fab	Composite		Supplier		
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		Inspection		Tube		\vdash	Cut Too Short	\vdash	Misread		 -	Power Loss/	_	Other	
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		Wave/Tw					Folio	Outside Dimensions							

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



95284

Work Order ID 95284

Thursday, January 24, 2013 12:27:24 PM Item ID: D3183-043 Revision ID: Item Name: Bracket Assembly Start Date: 1/7/2013 Required Date: 1/8/2013 Reference: Approvals: OC: Sequence ID/ Work Center ID 120 *120* Quality Control

Accept

N900040100

Setup Start

Start Oty: 3.00 Req'd Oty: 3.00

Operation

Cust Item ID: Customer:

CU-DAR001

Tool#

Plan

Code

RMA RA111456

Process Plan:

Date:

Tooling:

Date:

Start Run

Date:

SPC (Y/N):

Date:

Stop

Description

OC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours**

Tool ID

Accept Qty

Reject Reject Qty Number

Insp. Stamp

Memo

130

Identify as per dwg & Stock Location: 0.00

120 Packaging

Packaging

Memo

A236B

0.00

43/1/25 (3)

140

QC21- Final Inspection - Work Order Release

0.00

140

Memo

0.00

13/1/28 A)

Quality Control

												DQA:	Date:		
NCR:	⁄es	/ No					WORK ORDER NON-	COI	NFORM	MANCE / UPD	DATE	QA Closed:	 Date:		
Work Ord	<u> </u>						DISPOSITION				AGAINST DE	PARTMENT	PARTMENT/PROCESS		
Part No					•	Rework Scrap Use-as-is Work Order Update			Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite		- -i	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root Cause		Date	Step	Qty	Des		otion of work order update or Non-conformance	1	nitial nief Eng	Acti Descri		Sign & Date	Verification	QC Inspector	
occ/Data quip/Tooling Operator Material etup Other Process upplier Training			5,00												
							F	AUI	T CATE	GORY					
Landi	ng (Gear					General								
		Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend					Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread			Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
	<u> </u>			extrusio	n	\vdash	Drawing	\vdash	Offset Out of	Calibration				*	
	Torque Waves in Extrusion Turning Sequence						Finish		-	Sequence					

Outside Dimensions

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Wave/Twist in Tube

Folio

Picklist Print

Thursday, January 24, 2013 12:27:23 PM

Work Order ID:

95284

Parent Item:

D3183-043

Parent Item Name:

Bracket Assembly

Comments:

IPP Rev:Pick:A04.02.18New issueKJ/DS

IPP Rev:B Changed Mat Size 08-06-26 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	I
D3183-043 Bracket Assembly		Manufactured	No				Each	9.0000		3		
				Location		Loc Qty	Lo	c Code				

Location	Loc Qty	Loc Code	
ST235B	9		
85995	1		
89194	4		
90038	4		

3×82688 Mt 121-24

Start Date: 1/7/2013

Start Oty: 3.00

Page 1

Required Date: 1/8/2013

Required Qty: 3.00

Date

Status

Issued

												DQA:	Date:	
NCR:	/es	/ No					WORK ORDER NON-CONFORMANCE / UPDATE						 Date:	
						_						QA Closed:	Date.	
Work Orde	ar.						DISPOSITION			A	GAINST DEI	PARTMENT/	PROCESS	
vvoik Olde	-1.						Rework			Skid-tube Cro	osstube		Water Jet	Engineering
Part N	lo.						Scrap	1	i		nall Fab	Proc	d. Eng. Coor.	Quality
							Use-as-is		Thern	oforming F	inishing	Rec/Stor	e/Packaging	Other
NCR 1	١o.						Work Order Update			Large Fab Cor	mposite 🔃		Supplier]
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Root		D-4-	C4		Des		otion of work order update or Non-conformance		nitial	Action Description	n	Sign & Date	Verification	QC Inspector
Cause		Date	Step	Qty			r Non-comormance	CII	ief Eng	Description	!!	Date	Verification	QC IIISPECTOI
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	<u> </u>	Bending					Bend	<u> </u>	Grain			Ovalized		Pressure/Forced
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	Torque Waves in Extrusion Turning Sequence						Finish Out of Sequence							

Outside Dimensions

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Wave/Twist in Tube

Folio



RA111456

Received @ Dart January 3rd, 2013 Inspected@ Dart January 7th, 2013 Customer: VECTOR AEROSPACE Customer Contact: ALEX THIBAULT Shipped from: LANGLEY BC, CANADA

Instructions for RA 111456

- Parts returned are
 - o D3137-043 B83467 x3, B89427 x1, & B85867 x2
 - o D3183-043 B82688 x3
 - o D3183-044 B85996 x3
- Have instruction on all restocking work orders to buff out original B#'s and scribe in new ones in same location
- Needs new B#'s for restocking

Time Estimate = 3 HOURS (stores & small fab)

Departments Required: Stores & Small fab

<u>Pictures Attached</u> = NO

 $\underline{OTY \, INSPECTED} = QTY \, x6 \, D3137-043$

QTY x3 D3183-043

QTY x3 D3183-044

THIS INSTRUCTION SHEET MUST BE ATTACHED TO THE RESTOCKING WORK ORDER AT ALL TIMES!!!!

MODE ODDED NON CONFORMANCE / LIBRATE

DQA: Date:

NCR: Y	es / No				WORK ORDER NON-	LUINFUF	CIVIAINCE / UP	ZUATE	QA Closed:	Date	· ::			
Work Orde	·r·				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No.					Rework Scrap]	Skid-tube Crosstube Machining Small Fab			Water Jet d. Eng. Coor.	Engineering Quality			
raitiv	10.						rmoforming	Finishing	4	re/Packaging	Other			
NCR No.					Use-as-is Work Order Update] ^{thei}	Large Fab	Composite	Rec/Stor	Supplier	Other			
Root				Descri	ption of work order update	Initial	A	ction	Sign &					
Cause	Date	Step	Qty		or Non-conformance	Chief En	g Des	cription	Date	Verification	QC Inspector			
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	Cracks				Broken/Damaged	Inspe	ction Incomplete		Part Incorrect		Weld			
	Crushed/	Crimped			Burrs	Instru	ctions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled			
	Cuffs				Contamination	Main	tenance		Part Moved	_				
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ļ	Torque W	/aves in 8	Extrusio	n	Drawing	Out o	f Calibration							
	Turning S	equence			Finish	Out o	f Sequence							
Ī	Wave/Tw	ist in Tul	be		Folio	Outsi	de Dimensions							

